

*Spt*  
**Work Order ID 58502 - 1**

Friday, May 07, 2010 2:30:01 PM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-5-7*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3908

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*EP 10/05/12 (6)*

*EP 10/05/12 (6)*

*Dislodged*



*71*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Page 2

Item ID: D3908-041

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Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: Sub

0.00

Memo

0.00

10/07/13 (4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/13 (J)

MF  
0-5-13

W/O:			WORK ORDER CHANGES					
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# Picklist Print

Friday, May 07, 2010 2:30:00 PM

Page 1

Work Order ID: 58502

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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Lanyard Assembly

D3908-1



Lug Plate, Aft Crosstube

D3908-3



Stud Receiver, Lower

D3908-5



Eyebolt Stud

Location

ST095

57815

58344

Loc Qty

35

7

28

Loc Code

100

Each

2.0000

1

Location

ST095

57816

Loc Qty

2

2

Loc Code

100

Each

13.0000

1

Location

GA

57428

ST095

58347

Loc Qty

1

1

12

12

Loc Code

B58375 (6x)

B58345 (6x)



5/10/05/12

5/10/05/12

5/10/05/12

5/10/05/12

12

6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, May 07, 2010 2:30:00 PM

Page 2

Work Order ID: 58502



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010

Required Date: 5/13/2010

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3910-1		Manufactured	No			100	Each	12.0000	2			
Crosstube Lug												



*g 5/10/05/12*

*358341 (22)*

AN3C12A

Purchased

No



Bolts

Location	Loc Qty	Loc Code
ENG	11	
57194	11	
st507	1	
58353	1	

100

Each

176.0000

4



*g 5/10/05/12*

Location	Loc Qty	Loc Code
ST351	176	
112314	176	

100

Each

27.0000

1



*g 5/10/05/12*

MS17984-C413

Purchased

No



PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST297	4	
114340	4	
ST314	23	
114495	3	
114523	20	

*6*

Friday, May 07, 2010 2:30:01 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, May 07, 2010 2:30:01 PM

Page 3

Work Order ID: 58502



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010

Required Date: 5/13/2010

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REVB:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20615-4M20 RIVET	4M18 M114506	Purchased	No			100	Each	204.0000	6		5/10/05/12	

Location	Loc Qty	Loc Code
ST323	204	
113254	16	
114324	4	
114349	184	

MS21043-3 Nut		Purchased	No			100	Each	3,735.000	4		5/10/05/12	
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Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	3655	
112314	3655	

NAS1149C0332R Washer		Purchased	No			100	Each	3,238.000	8		5/10/05/12	
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Location	Loc Qty	Loc Code
ST297	3238	
113524	10	
113737	150	
114341	3078	

Friday, May 07, 2010 2:30:01 PM

Shop Packet Print

Page 3

W/O:			WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

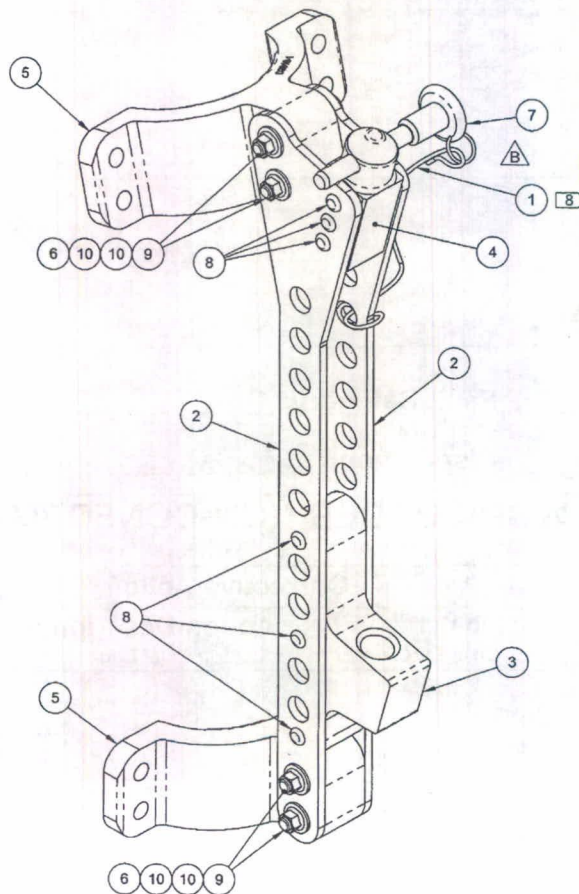
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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



RELEASED  
2010-04-14  
MP

**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

B	BOM: D3908-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
REV.	NEW ISSUE	JPH	10.03.04
DESIGN	JPH	DESCRIPTION	BY DATE
DRAWN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3908	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG ASSY (AFT)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

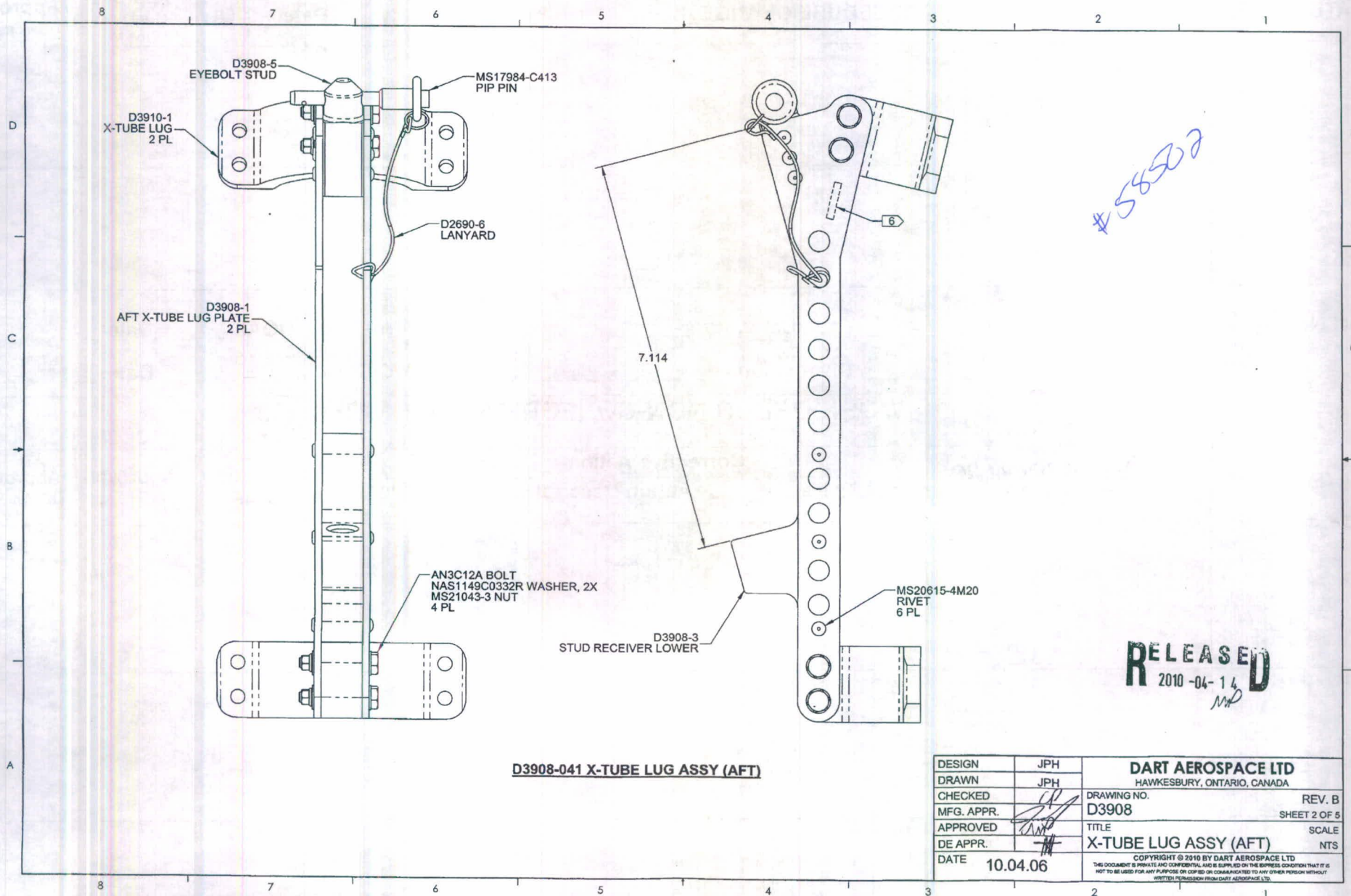
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





*58502*

**RELEASED**  
2010-04-14  
*MD*

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3908</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>X-TUBE LUG ASSY (AFT)</b>	SHEET 2 OF 5
DE APPR.	<i>[Signature]</i>	SCALE NTS	
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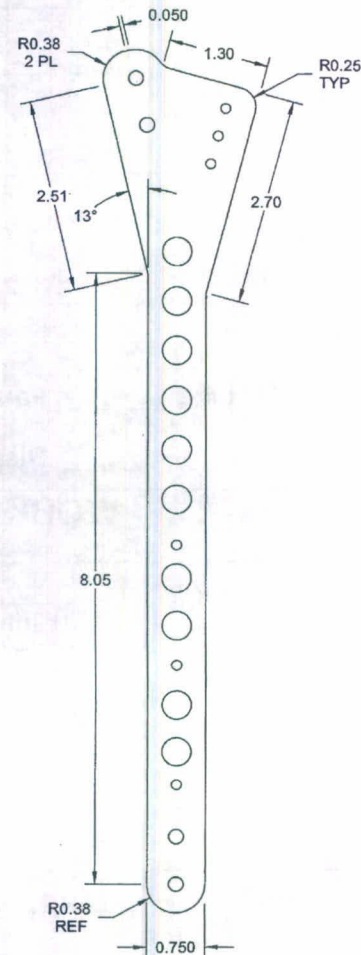
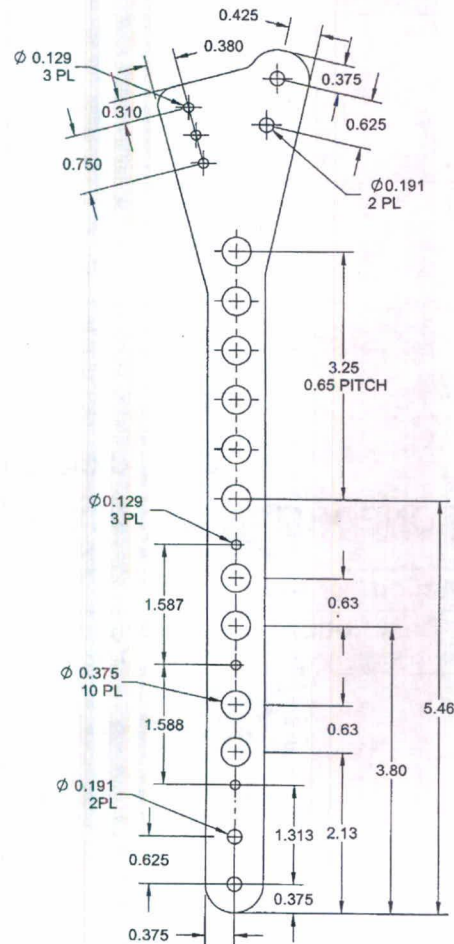
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





#58302

RELEASED  
2010-04-14  
MD

# NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.32 lbs

## D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3908	REV. B
MFG. APPR.	JPH	TITLE X-TUBE LUG ASSY (AFT)	SHEET 3 OF 5
APPROVED	JPH	SCALE	NTS
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

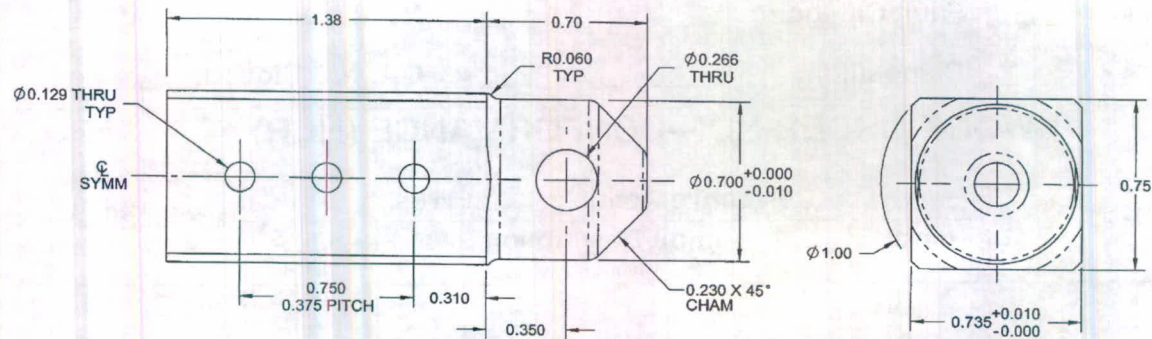
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**NOTE:** Date & initial all entries





**D3908-5 EYEBOLT STUD**



**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3908</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>X-TUBE LUG ASSY (AFT)</b>	SHEET 5 OF 5
DE APPR.	<i>[Signature]</i>	SCALE NTS	
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**RELEASED**  
2010-04-14  
*MP*

*#58507*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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